



# 3443-63 LOCATOR PLATE

## Instructions for the assembly of Scotchflex Card-Edge Connector

### General:

Scotchflex manual and pneumatic assembly presses and accessory Assembly Equipment are recommended for the termination of Scotchflex Card-Edge Connectors. Scotchflex Assembly Equipment is offered to reduce

set-up time, to provide easy and fast assembly, and to reduce assembly error. The 3443-63 Locator Plate is designed to assemble all Card-Edge connectors.

Number of Contacts	Connector Part Number	Keying Plug Number	Strain Relief Number	Locator Plate Number 3443	Platen Plate Number 3442	Shut Height Adjustment for 3M Assembly Presses		
						3640	3335 3316	3830
10	3358	↑ 3439-2 ↓	3448-52	↑ -63 ↓	↑ -30 ↓	↑ 18 1/2 ↓	↑ 19 ↓	*see below
16	3368		3448-53					
20	3461		3448-54					
26	3462		3448-55					
34	3463		3448-56					
40	3464		3448-57					
50	3415		3448-58					
60	3666		3448-31					
64	3403		3448-59					

\*The 3830 Pneumatic Press Shut Height is self adjusting. See the 3830 Pneumatic Press adjustment instruction.

### Procedure for Set-up:

Adjustments to the Connector Guides are required for set-up relative to style and length of the Card Edge Connector.

1. Position **connector guides** for the appropriate number of contacts in the connector. Numbers are found at both ends of the guides. Align both guide notches with the proper position number. Lift and rotate the connector guides as necessary to obtain proper alignment. (Figure 1)
2. Install locator plate on the press table over the mounting studs.

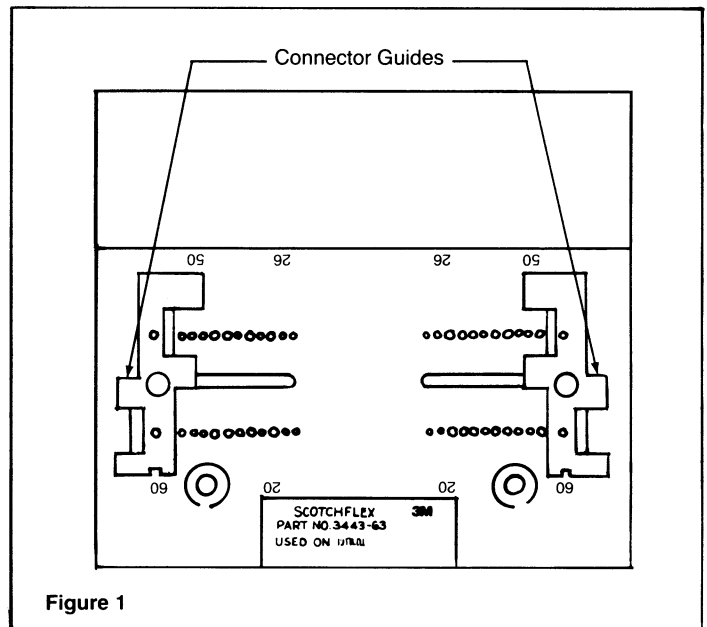


Figure 1

## Procedures for Adjusting Shut Height:

The shut height setting is referenced in the chart on page 1. Shut height settings are guidelines for proper termination depth.

1. The shut height adjustment is made from the base of the assembly press without the locator plate in place.

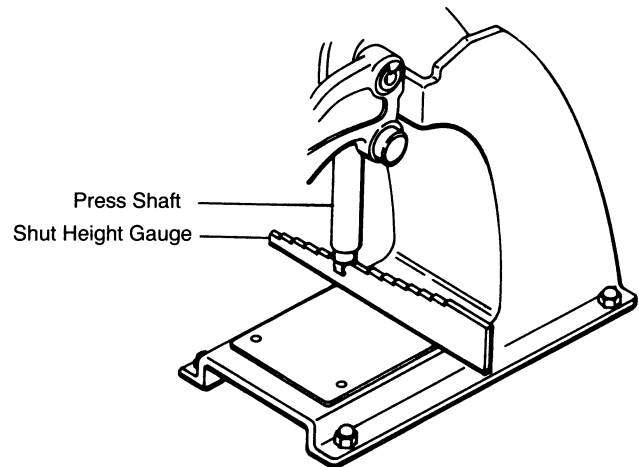
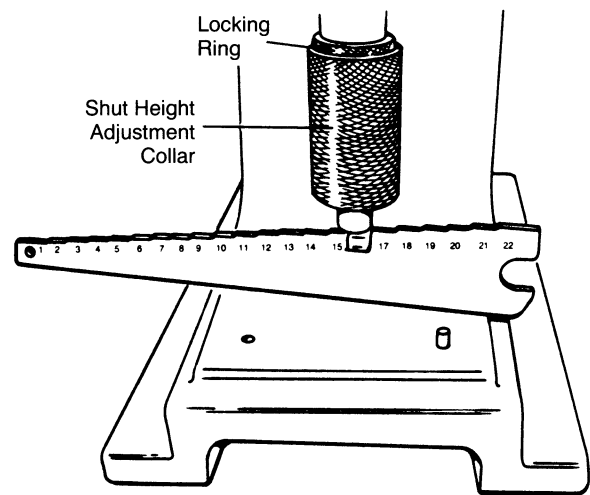


Figure 2

2. Place the shut height gauge, #3436-1A, across the press base. (See Figures 2 and 3)

3. Lower the handle of the press until the handle casting makes contact with the press casting. (See Figure 2)

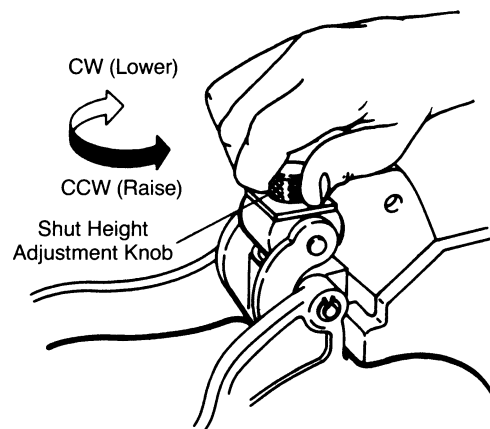


3335 Assembly Press

Figure 3

4. Rotate the shut height adjustment feature until the bottom of the shaft contacts the desired position on the gauge. (See Figure 3 and 4)

5. Install the locator plate and the appropriate platen on the press. The platen should be positioned parallel with the connector body and cover.



3540 Assembly Press

Figure 4

## Procedures for Connector/Cable Assembly:

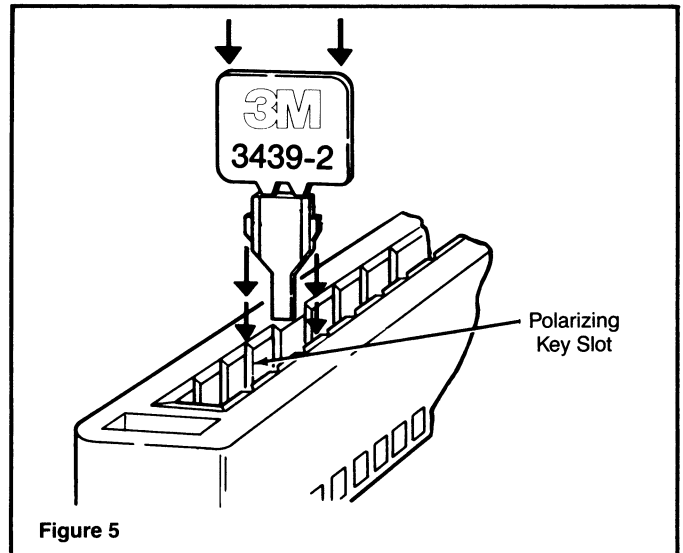
1. Replace the platen in parallel alignment with the connector body. Refer to table on page one for proper platen.
2. Rub thumb along length of paper liner to insure maximum adhesive transfer to the cover; then remove liner.
3. Press cable ribs into cover alignment grooves.
4. Visually inspect to insure that:
  - a. Cable is properly aligned and oriented in cover grooves.
  - b. Cable end is flush with cover for end terminations, or perpendicular to cover for mid-span terminations.
5. Position the card-edge connector body in the locator plate, contacts up. Orient the connector for pin #1 to conductor #1 assembly.
6. Place the cable/cover sub-assembly over the connector body, inserting cover clips into body ports.
7. Lower the assembly press handle fully to complete the connection.
8. Raise the handle and remove the completed assembly.
9. Visually inspect to insure that:
  - a. Cover is fully seated and parallel to body.
  - b. Cover retaining device is fully engaged with the body.

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## Polarizing:

### 3439-2 Key

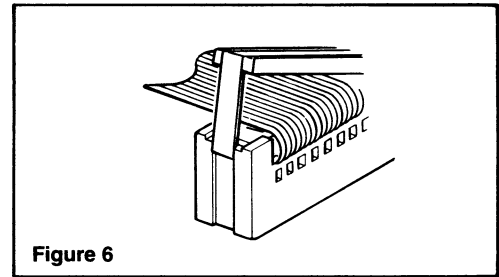
1. Insert polarizing key into desired key slot in connector, pushing until key bottoms in connector. Some resistance will be felt as the edge fins of the key meet the connector.
2. Gently bend tab back and forth to break away from polarizing key.
3. Cut slot in printed circuit board "tongue" to correspond with polarizing key position.



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## Strain Relief Attachment:

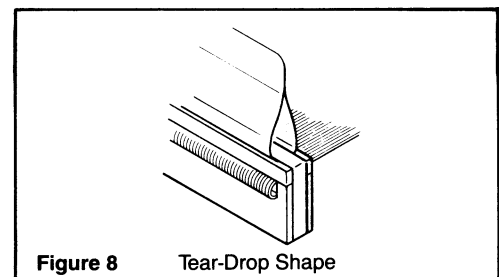
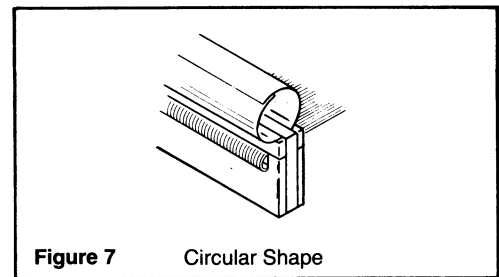
1. Fold cable back over cover.
2. Engage one end of strain relief into strain relief retainer slot. (2 piece strain relief)
3. Push down on opposite end until strain relief snaps into place. (Figure 5)



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## Pull Tab Attachment:

1. Insert Pull Tab beneath the strain relief. Remove protective liner.
2. Bring ends together to form circular or tear-drop shape. (Figure 6 & 7)



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